

Work Order ID 58344

Monday, May 03, 2010 3:01:45 PM



Page 1

Item ID: D3908-1

Accept



Setup Start



Revision ID:

Item Name: Lug Plate, Aft Crosstube

Stop



Start Date: 5/4/2010 Start Qty: 24.00



Cust Item ID:

Required Date: 5/4/2010 Req'd Qty: 24.00



Customer:

Reference:

Approvals: Process Plan: MFDate: 10-5-3

Tooling:

Date:

Run Start



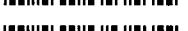
QC: _____

Date: _____

SPC (Y/N):

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr	Revision Nbr
D3908	B

100

0.00



Waterjet

Memo

0.00

E 10-5-4

FLOW CNC Waterjet

Cut as per dwg D3908
Prog Rev: B
Dwg Rev: B

Deburr as required



110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

E 10-5-4

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 58344

Monday, May 03, 2010 3:01:45 PM



Page 2

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Accept



Setup Start

**Revision ID:****Item Name:** Lug Plate, Aft Crosstube

Stop

**Start Date:** 5/4/2010 **Start Qty:** 24.00**Cust Item ID:****Required Date:** 5/4/2010 **Req'd Qty:** 24.00**Customer:****Reference:****Approvals:** Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

**Sequence ID/
Work Center ID****Operation
Description****Set Up/
Run Hours****Draw
Number****Draw
Rev.****Plan
Code****Accept
Qty****Reject
Qty****Reject
Number****Insp.
Stamp**

120

QC8- Inspect parts - second check

0.00

Sidoros

cento
128

Pb →



QC

Quality Control

Memo

0.00

150

Identify as per dwg & Stock Location

94

0.00

10-5-5

20-1



Packaging

Memo

0.00

Packaging

160

QC21- Final Inspection - Work Order Release

0.00

10/05/06 HJ

MF 10-5-6



QC

Quality Control

Memo

0.00

W/O: 58344		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/05/05	# 120	Took Qty +1 Per inspection Template	S	Webster	(R)		S 10/05/05

Part No: D 3908-1 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, May 03, 2010 3:01:44 PM

Page 1

Work Order ID: 58344



Parent Item: D3908-1



Parent Item Name: Lug Plate, Aft Crosstube

Start Date: 5/4/2010

Required Date: 5/4/2010

Comments: IPP RevA: new issue DD 09.11.17 verified by:EC
per dwg revB DD 10.04.20 verified by:EC

IPP Rev:B as

Start Qty: 24.00

Required Qty: 24.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
M304S11GA		Purchased	No			100	sf	66.8500	0.0533	25		BL0-5-4

304/316 0.125 Sheet

Location	Loc Qty	Loc Code
MAT	62.38	
114488	62.38	
MAT19	4.47	
112663	4.47	1D(603)

29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	58344
Description: Lug Plate, Aft Crosstube	Part Number:	D3908-1
Inspection Dwg: D3908 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Measured by: <u>AB</u>	Audited by: <u>S</u>	Preliminary Approval: <u>u</u>
Date: <u>10-5-4</u>	Date: <u>W/2015</u>	Date: <u>1/19</u>

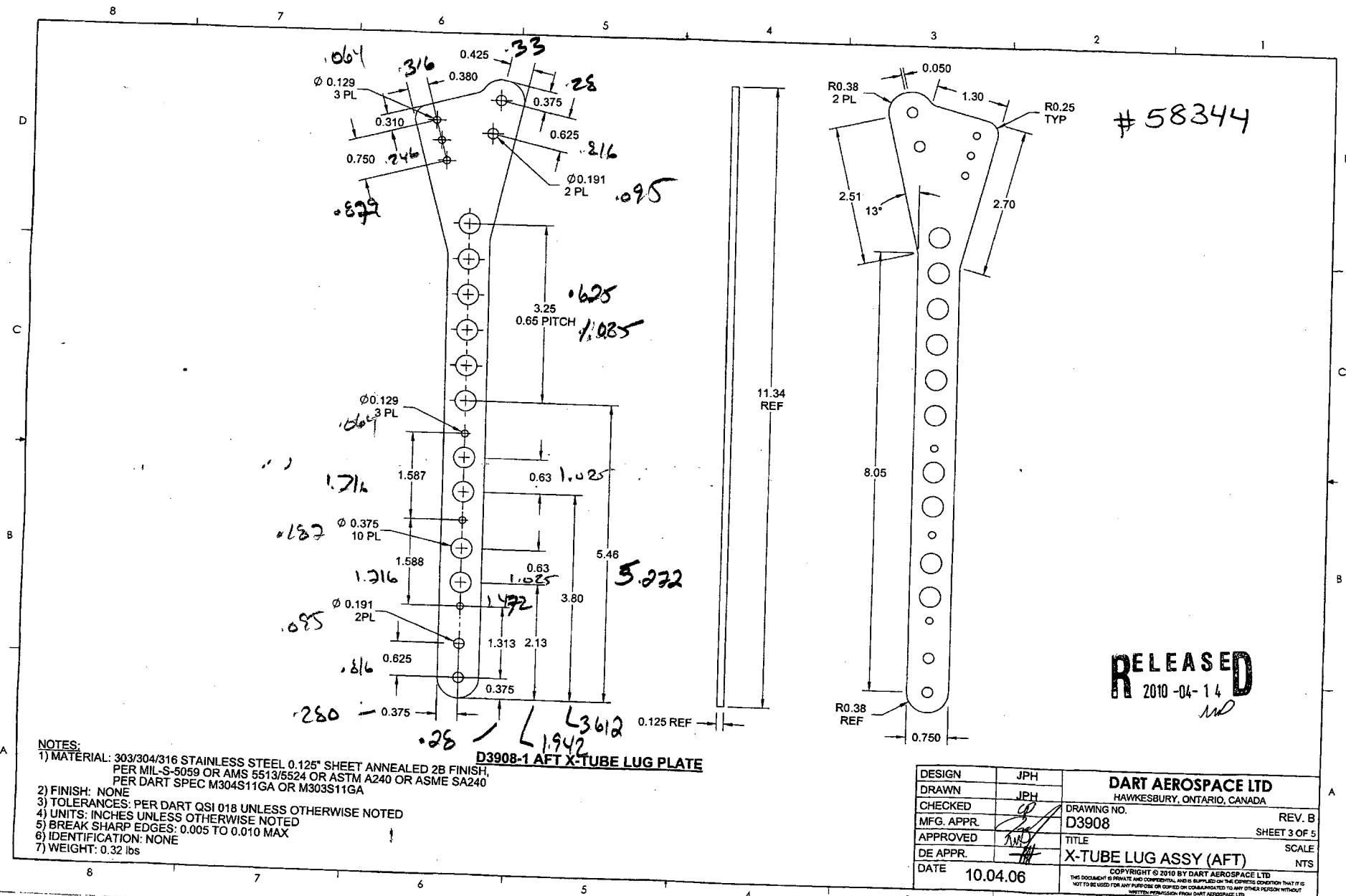
Rev	Date	Change	Revised by	Approved
A	10.04.01	New Issue	KJ	
B	10.04.20	Dimensions updated per Dwg Rev B	KJ	X M

W/O:		WORK ORDER CHANGES					
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 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries



NOTES:

- D3908-1 AFT X-TUBE LUG PLATE**

1) MATERIAL: 303/304/316 STAINLESS STEEL 0.125" SHEET ANNEALED 2B FINISH,
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
PER DART SPEC M304S11GA OR M303S11GA

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

7) WEIGHT: 0.32 lbs

DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	JPH			
CHECKED	<i>CD</i>	DRAWING NO.	REV. B	
MFG. APPR.	<i>S/N</i>	D3908	SHEET 3 OF 5	
APPROVED	<i>AMY</i>	TITLE	SCALE	
DE APPR.	<i>TH</i>	X-TUBE LUG ASSY (AFT) NTS		
DATE	10.04.06	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PROPRIETARY AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OTHER THAN THE ORIGINAL PURCHASED BY THE OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD		

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